

Date: Monday, 02/06/2008 10:41:18 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job Number	: 39628		
Estimate Number	: 11073		
P.O. Number	:	Part Number	: D31373
This Issue	: 02/06/2008 S.O. No. :	Drawing Number	: D3137 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 /	Drawing Revision	: E
Previous Run	: 39449	Material	:
Written By	: <u>JL 02-06-02</u>	Due Date	: 09/06/2008 Qty: 20 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A 02.05.29 New Issue NG Est Rev:B 08-05-23 revE as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLNB075X1250	Delrin Bar
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Comment: Qty.: 0.0831 f(s)/Unit Total: 1.6611 f(s)
 Matl:Black Delrin bar 1.250" x .750"
 (ref DART spec. M-DELRIN-B)
 Batch: M14535

JL 08/06/02

(20)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut Blanks.Blank size: 1.250" x .750" x .950" long

JL 08/06/02

(20)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA242 & Dwg D3137

2-Deburr

JL 08/06/03

(20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/06/03

(20)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 08/06/03 (420) counters

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Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 8/6/4 *(20)*

7.0

QC21

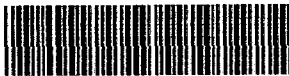
FINAL INSPECTION/W/O RELEASE



08/06/04 *JS*

Comment: FINAL INSPECTION/W/O RELEASE

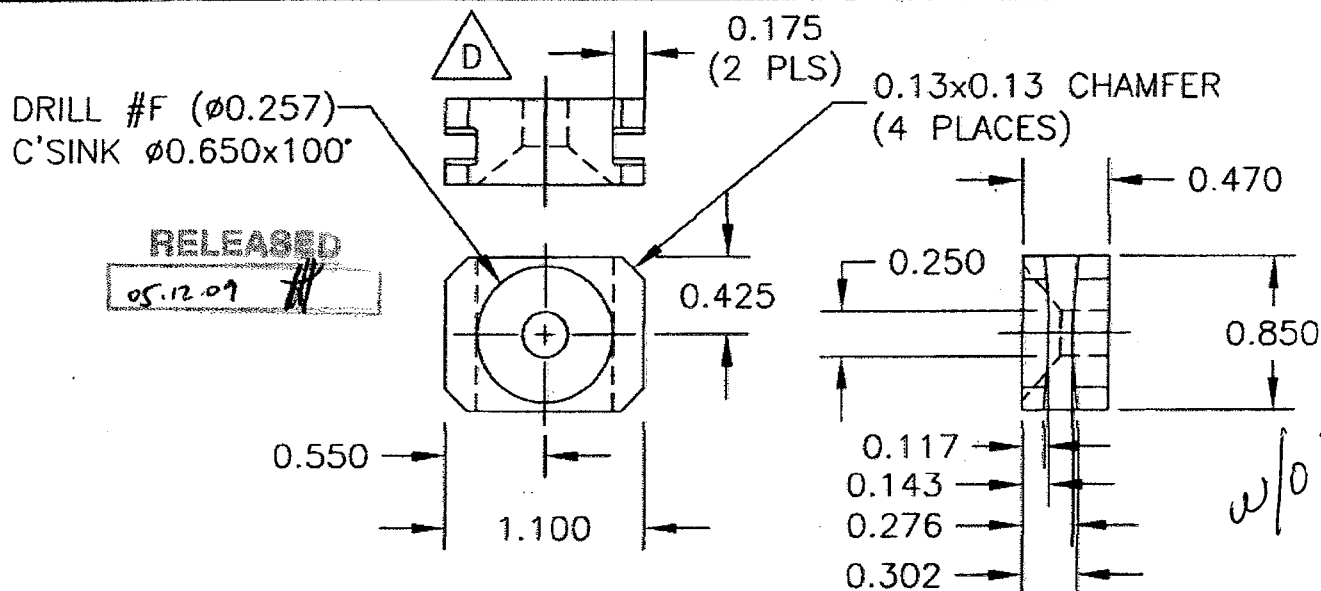
Job Completion



MF 08-06-04

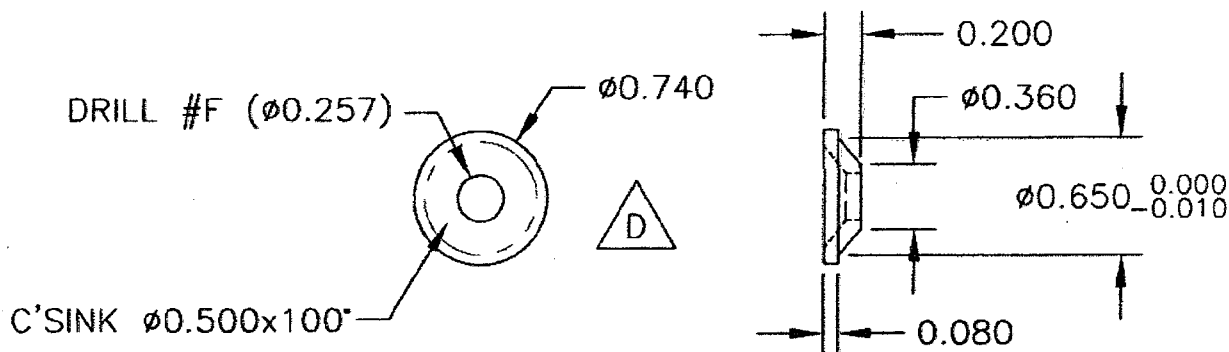


DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3137	REV. E SHEET 3 OF 5
DATE 05.11.23	TITLE BRACKET ASSEMBLY		SCALE 1:1



D3137-3 GUIDE

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015



D3137-5 WASHER

- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

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